



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

DSI 9053-011
Job Sheet 170352



Part No: DSI 9053-011

Job Qty: 2 ea

Part Name: Basket Hinge



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/15/18

Job Tracking No:

Due Date: 1/29/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 02.05.15 New Issue NG

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		1/29/18	0.00	0.00	Start Up Stores/Pkg-1		810281 NVT
110	Packaging	2 pcs		1/29/18	0.00	0.00	Packaging1-5		JAN 18 2018
120	QC	2 pcs		1/29/18	0.00	0.00	QC4		Sms
125	DC	2 pcs		1/29/18	0.00	0.00	DC		
130	Packaging	2 pcs		1/29/18	0.00	0.00	Packaging3-2		Sms
140	QC21-FG	2 Ea		1/29/18	0.00	0.00	QC21		DAS 21 2018

Part Op 110 - Pick Kit

Descriptions: 120 - QC4- 100% Inspect kits for completeness

125 - Photocopy bluefile and create labels as per PPP DSI 9053-011 CHG001

130 - Identify and pack for shipping as per PPP DSI9053-011 Location:FG123_ PPP Rev: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MS21042L4	4	3,205	0	0
120-QC	AN3-12A	8	80	0	0
	AN3-14A	12	262	0	0
	AN4-6A	4	631	0	0
	D2232-1	4	9	0	0
	D2232-3	4	6	0	0
	MS21042L3	20	3,015	0	0
	NAS1149D0363J	80	4,264	0	0
	NAS1149D0463J	16	5,305	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com		DSI 9053-011 Original Serial #: S033259 Revision: Operation: Change No:		Start up Operation 01/18/18 Job No: 170352 CHG001		AGAINST DEPARTMENT/PROCESS <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td>tube</td><td>☐</td> <td>Cross tube</td><td>☐</td> <td>Water Jet</td><td>☐</td> <td>Engineering</td><td>☐</td> </tr> <tr> <td>ining</td><td>☐</td> <td>Small Fab</td><td>☐</td> <td>Prod. Eng. Coord.</td><td>☐</td> <td>Quality</td><td>☐</td> </tr> <tr> <td>ming</td><td>☐</td> <td>Finishing</td><td>☐</td> <td>Rec/Store/Packaging</td><td>☐</td> <td>Other</td><td>☐</td> </tr> <tr> <td>e Fab</td><td>☐</td> <td>Composite</td><td>☐</td> <td>Supplier</td><td>☐</td> <td></td><td>☐</td> </tr> </table>				tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐	ining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐	ming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐	e Fab	☐	Composite	☐	Supplier	☐		☐
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								QC / QA Coordinator Approval																																			

Root Cause <table border="1" style="width: 100%; border-collapse: collapse;"> <tr><td>Environment</td><td>☐</td><td>No</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Op</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Off</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Sup</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Trai</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poc</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rus</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table>		Environment	☐	No	☐	Design	☐	Op	☐	Doc/Data	☐	Off	☐	Equip/Tooling	☐	Sup	☐	Handling/Pre	☐	Trai	☐	Material	☐	Use	☐	Internal Transport	☐	Poc	☐	Tribal Knowledge	☐	Rus	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	Wave/Twist in Tube Marks/Chatter		Instructions Incomplete/Unclear Drill Holes		FAULT CATEGORY <table border="1" style="width: 100%; border-collapse: collapse;"> <tr><td>Cure</td><td>☐</td><td>Power Loss/Surge</td><td>☐</td><td>Positioned Wrong</td><td>☐</td></tr> <tr><td>ge/Defect</td><td>☐</td><td>Folio/Program</td><td>☐</td><td>Outside Dimensions</td><td>☐</td></tr> <tr><td>omplete/Unqualified</td><td>☐</td><td>Grain</td><td>☐</td><td>Over/Under tolerance</td><td>☐</td></tr> <tr><td>n</td><td>☐</td><td>Weld</td><td>☐</td><td>Part Incorrect</td><td>☐</td></tr> <tr><td></td><td>☐</td><td>Wrong Stock Pulled</td><td>☐</td><td>Part Lost/Missing</td><td>☐</td></tr> <tr><td></td><td>☐</td><td>Out of Sequence</td><td>☐</td><td>Part Moved</td><td>☐</td></tr> <tr><td></td><td>☐</td><td>Off-set</td><td>☐</td><td>Drawing</td><td>☐</td></tr> <tr><td></td><td>☐</td><td>Mislabeled</td><td>☐</td><td>Finish</td><td>☐</td></tr> <tr><td></td><td>☐</td><td>Fit/Function</td><td>☐</td><td>Misread</td><td>☐</td></tr> <tr><td></td><td>☐</td><td>Misaligned/off center</td><td>☐</td><td>Turning Sequence</td><td>☐</td></tr> </table>		Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐	ge/Defect	☐	Folio/Program	☐	Outside Dimensions	☐	omplete/Unqualified	☐	Grain	☐	Over/Under tolerance	☐	n	☐	Weld	☐	Part Incorrect	☐		☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐		☐	Out of Sequence	☐	Part Moved	☐		☐	Off-set	☐	Drawing	☐		☐	Mislabeled	☐	Finish	☐		☐	Fit/Function	☐	Misread	☐		☐	Misaligned/off center	☐	Turning Sequence	☐
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DART

DESIGN UP	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. DSI 9053	REV. B SHEET 1 OF 2
DATE 01.04.16		TITLE BASKET HINGE CHANGE	SCALE NTS
A	96.11.06	NEW ISSUE	
B	01.04.16	REDRAWN	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION DRAWING D205-541 REV. D
(REF. CANADIAN STC: SH96-120, FAA STC: SR00696NY)
AND INSTALLATION DRAWING D350-607 REV. E
(REF. CANADIAN STC: SH94-14, FAA STC: SR00213NY)

IF THE D2569 HINGE IS BEING REPLACED, THE PARTS LIST OF D205-541 REV. D (D205-541-011 CHG 003) / D350-607 REV. E (D350-607-041/-042 CHG 004) SHOULD BE AMENDED AS FOLLOWS:

REPLACE:

Qty	Part Number	Description
1	D2569	HINGE
36	AD64ABSLF	RIVET

WITH:

Qty	Part Number	Description
X	DSI 9053-011	HINGE CHANGE KIT
2	D2232-1	HINGE PLATE
2	D2232-3	HINGE PLATE
4	AN3-12A	BOLT
6	AN3-14A	BOLT
2	AN4-6A	BOLT
40	AN960JD10	WASHER*
8	AN960JD416	WASHER*
10	MS21042L3	NUT (OR MS21042-3)
2	MS21042L4	NUT (OR MS21042-4)

* NOTE: IT IS ALSO ACCEPTABLE TO REPLACE THE WASHERS THAT ARE USED AS SPACERS WITH A SINGLE ALUMINUM SPACER OF APPROPRIATE LENGTH (SEE PAGE 2).

REPLACE D2569 HINGE AS FOLLOWS:

- 1) REMOVE EXISTING HINGE BY DRILLING OUT AD64ABSLF RIVETS. PLUG HOLES WITH RIVETS IF DESIRED.
- 2) DRILL HOLES IN D2232-1/-3 HINGE PLATES AS SHOWN ON PAGE 2.
- 3) LOCATE D2232-1 HINGE PLATE ON D2512 BASKET LID ASSEMBLY. REMOVE MESH AS REQUIRED SO THAT D2232-1 HINGE PLATE SITS FLUSH ON D2512 BASKET LID ASSEMBLY. TRANSFER DRILL Ø0.191 HOLES. INSTALL D2232-1 HINGE PLATE WITH HARDWARE AS SHOWN ON PAGE 2. REPEAT AT OTHER END OF BASKET.
- 4) LOCATE POSITION OF D2232-3 HINGE PLATE FROM D2232-1 HINGE PLATE BY ENSURING Ø0.257 HOLE IS ALIGNED. REMOVE MESH AS REQUIRED TO ENSURE THAT D2232-3 HINGE PLATE AND ATTACHMENT HARDWARE SITS FLUSH AGAINST D2206/D2221 BASKET BASE ASSEMBLY. TRANSFER DRILL Ø0.191 HOLES. INSTALL D2232-3 HINGE PLATE WITH HARDWARE AS SHOWN ON PAGE 2. REPEAT AT OTHER END OF BASKET.
- 5) TOUCH UP PAINT AS REQUIRED.

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Change Record

Part Number DSI 9053-011
Description HINGE CHANGE KIT

Page ____ of ____

[illegible]

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: AN3-12A Revision: Bolt														
100	Receive Ea	S032921	170352	8 Ea	0	153854	Start Up Stores/Pkg-1		Stock	1/17/2018	Issue Container			
Operation Totals:		1		8	0									
Part Totals:		1		8	0									
Part Number: AN3-14A Revision: Bolt														
100	Receive Ea	S032917	170352	4 Ea	0	M138040	Start Up Stores/Pkg-1		Stock	1/17/2018	Issue Container			
Operation Totals:		1		4	0									
Part Totals:		1		4	0									
Part Number: AN4-6A Revision: Bolt														
100	Receive Ea	S032911	170352	4 Ea	0	M138045	Start Up Stores/Pkg-1		Stock	1/17/2018	Issue Container			
Operation Totals:		1		4	0									
Part Totals:		1		4	0									
Part Number: DSI 9053-011 Revision: Basket Hinge														
140	QC21-FG	S033259	170352	2 Ea	0	S033259	FG123		Stock	1/18/2018	Issue Container			
Operation Totals:		1		2	0									
Part Totals:		1		2	0									
Part Number: MS21042L3 Revision: Nut														
100	Receive Ea	S032880	170352	20 Ea	0	S016501	Start Up Stores/Pkg-1		Stock	1/17/2018	Issue Container			
Operation Totals:		1		20	0									
Part Totals:		1		20	0									
Part Number: MS21042L4 Revision: Nut														
100	Receive Ea	S032925	170352	4 Ea	0		Start Up Stores/Pkg-1		Stock	1/17/2018	Issue Container			
Operation Totals:		1		4	0									
Part Totals:		1		4	0									
Part Number: NAS1149D0363J Revision: Washer														
100	Receive Ea	S032871	170352	69 Ea	0		Start Up Stores/Pkg-1		Stock	1/17/2018	Issue Container			
Operation Totals:		1		69	0									
Part Totals:		1		69	0									
Part Number: NAS1149D0463J Revision: Washer														
100	Receive Ea	S032874	170352	16 Ea	0		Start Up Stores/Pkg-1		Stock	1/17/2018	Issue Container			
Operation Totals:		1		16	0									
Part Totals:		1		16	0									
Totals:		8		127	0									

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					